

**Ship Via:**

https://www.plexonline.com/1311f84e-dfb7-41d0-a816-7e8c62494859/Plexus_Control/Report_Viewer_2.asp?URL=https://www.plexonline.com/1311f84e-dfb7-41d



Container No: S075347



Part: C45-4-1

Job No: 177369

Serial No/Batch: S075347

Revision: 3A

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/29/18



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C45-4-1

Job Sheet 175723



24

Part No: C45-4-1

Job Qty: 20 ea

Part Name: Trunnion Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/10/18

Job Tracking No:

Due Date: 4/20/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG C45-4-1 Rev 3A IPP Rev A 18.02.08 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		4/19/18	0.00	0.00	Start Up Machining-4		
120	Mori Seiki	20 pcs		4/20/18	0.00	2.00	MORI SL-154		
130	QC	20 pcs		4/20/18	0.00	0.00	QC2 Machining-5		
140	QC	20 pcs		4/20/18	0.00	0.00	QC8 Machining-5		
150	Packaging	20 pcs		4/20/18	0.00	0.00	Packaging3-2		
160	QC21-SA	20 Ea		4/20/18	0.00	0.00	QC21		

Part Op 120 - 1-Machine as per folio FB853 FOLIO REV: _____ DWG REV: _____ 2-Deburr
Descriptions: 150 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-BRONZE-C63000-R1.250	Bronze C63000 Round Bar 1.25"	.9800 ft (.049 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-BRONZE-C63000-R1.250	1	2	0

Part Specifications

Specifications could not be found.

Plex 4/10/18 12:55 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

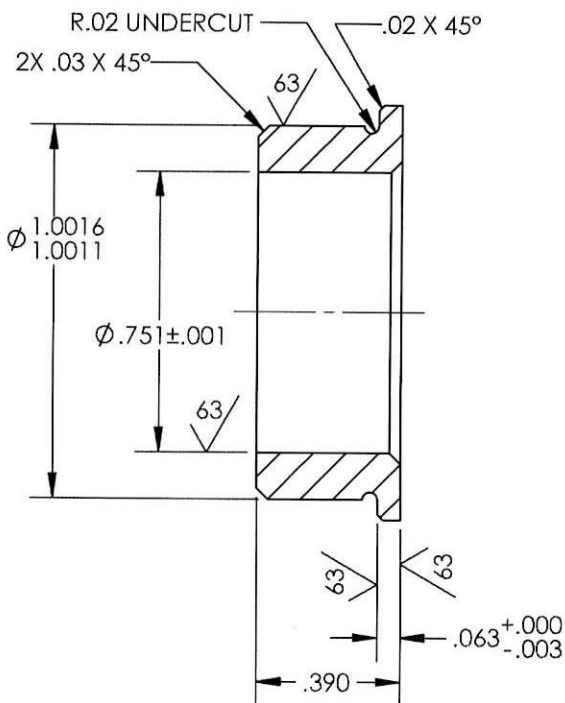
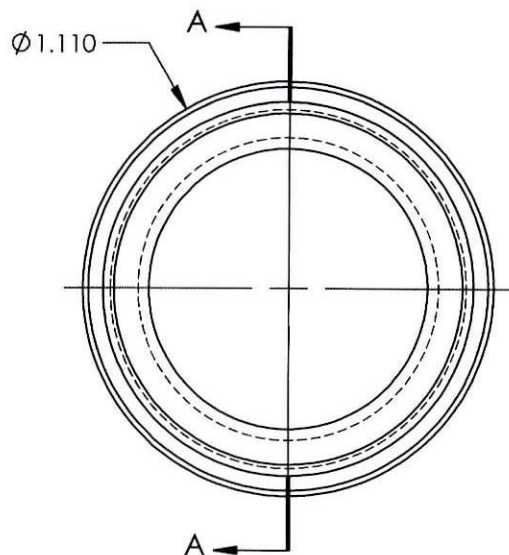
QA Closed: _____ Date: _____

Work Order update only ☐

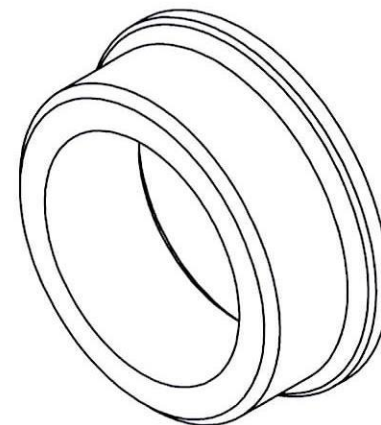
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐			FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					

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REV	ECR	REVISIONS		
		DESCRIPTION	DATE	INITIAL
3		AS DRAWN BY CANAM.	9/12/2012	RJC
3A	14-0127	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED BAG & LABEL NOTE. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	8/13/2014	DPD
				RW



SECTION A-A



NOTE:
BAG & LABEL WITH BATCH NUMBER.

DART AEROSPACE	
TITLE TRUNNION BUSHING	
DWG NO. C45-4-1	REV 3A
MAT'L AL-BRONZE 630	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Well</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 2:1	DATE 5/14/1997
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C45-4-1	1	TRUNNION BUSHING	AL-BRONZE 630	Ø1-1/4 X 1/2 MCMASTER-CARR #8203K812

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Description Work Order Deviation				Disposition				Completed By																																																									
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								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039860**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO039860
PO Date: 5/10/18
Due Date: 6/8/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Lussier, Patrick

Via: Ground
Pynt Terms: Net 60

Freight Terms:
Special Comments:

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	C3-4-1P			Load Beam Bushing	Firmed	6/8/18	50 pcs	0 pcs	50 pcs	\$0.01/pcs	\$0.50
Line Item Note W/O 177361											
2	C3-8-2-2P			Solenoid Drilling Jig C3 Hook	Firmed	6/8/18	30 pcs	0 pcs	30 pcs	\$0.01/pcs	\$0.30
Line Item Note W/O 177362											
3	C3-12-2P			Lock Shaft	Firmed	6/8/18	30 pcs	0 pcs	30 pcs	\$0.01/pcs	\$0.30
Line Item Note W/O 177363											
4	C45-3-8BP			Actuator Shaft Bushing Solenoid Side	Firmed	6/8/18	40 pcs	0 pcs	40 pcs	\$0.01/pcs	\$0.40
Line Item Note W/O 177364											
5	C45-3-8AP			Actuator Shaft Bushing	Firmed	6/8/18	40 pcs	0 pcs	40 pcs	\$0.01/pcs	\$0.40
Line Item Note W/O 177367											
6	C45-4-1P			Trunnion Bushing	Firmed	6/8/18	50 pcs	0 pcs	50 pcs	\$0.01/pcs	\$0.50
Line Item Note W/O 177369											
7	C10-23-1P			Keeper Spacer	Firmed	6/8/18	50 pcs	0 pcs	50 pcs	\$0.01/pcs	\$0.50
Line Item Note W/O 177373											
8	RBW6305G01232-3G-5P			Spacer	Firmed	6/8/18	25 Ea	0 Ea	25 Ea	\$0.01/Ea	\$0.25
Line Item Note W/O 177396											

Plex 5/10/18 1:38 PM dart.Lussier.Patrick



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 673-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

DAS
11
9-89

MAY 29 2018

Quantity	Part Number	Part Name	P.O. Number
50	DART C3-4-1P	Load Beam Bushing	39860
32	DART C3-8-2-2P	Solenoid Drilling Jig C3 Hook	39860
40	DART C45-3-8BP	Actuator Shaft Bushing Solenoid Side	39860
40	DART C45-3-8AP	Actuator Shaft Bushing	39860
50	DART C45-4-1P	Trunnion Bushing	39860

MATERIAL: supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, May 25, 2018